

Work Order ID 86437

June-28-12 1:03:54 PM

86437

Page 1

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 28/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

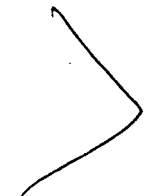
QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 5-Deburr								
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120	HandFinish								
Hand Finishing	Memo	0.00							



B 12/07/18

OC 12/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86437

June-28-12 1:03:54 PM

86437

Page 2

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 350 l Beam

Stop ***NS2***

Start Date: 28/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG</u> Memo	0.00 0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DAS
03
28

DP

12-7-18

DC 12/07/18

4

12/7/20

ME
12-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-28-12 1:03:57 PM

Page 1

Work Order ID: 86437

86437

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-5-108

Manufactured

No

100

Each

104.0000

1

4

D2600-5-108

Extrusion 'I' Beam' thin

**

4

3/2/07/18

Location

Loc Qty

Loc Code

LG

104

47814

20

73909

84

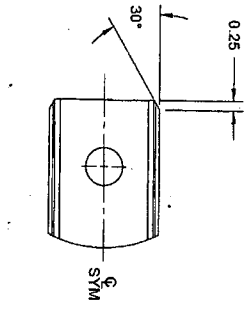
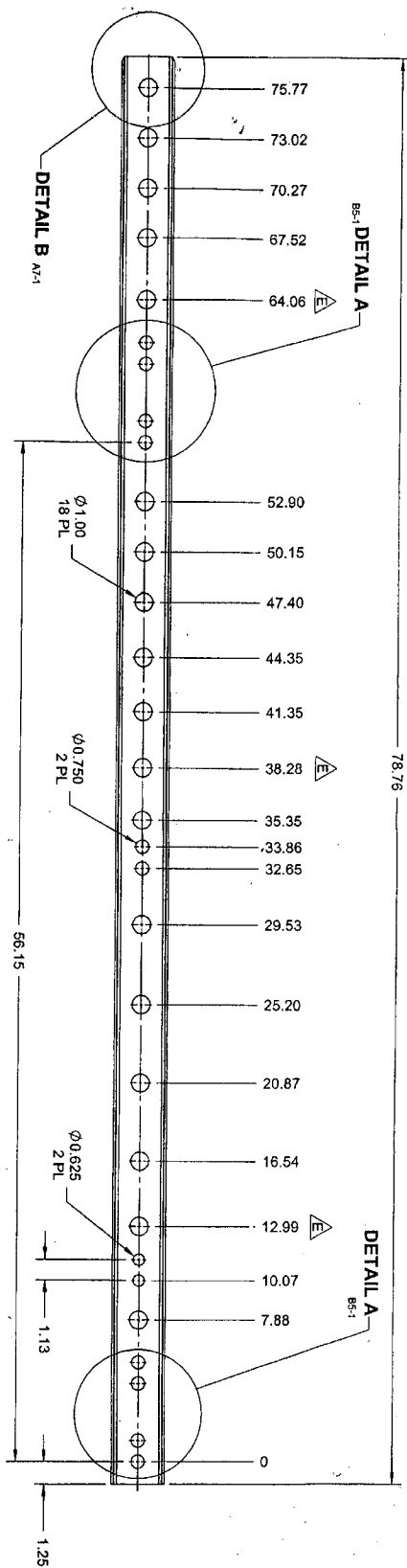
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

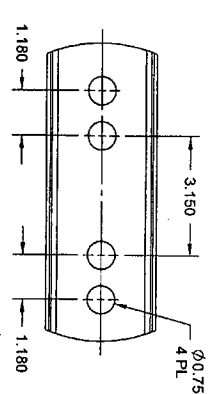
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL B
SCALE 3X
C7-1



DETAIL A
SCALE 3X
D7-1, D8-1

- NOTES:
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK START EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART PIN D2739 AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26437 MC
12/26/28

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DS	98.04.16
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAFTER	CP	98.11.18
C	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
D	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
E	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
F	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
G	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
H	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
I	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
J	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
K	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
L	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
M	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
N	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
O	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
P	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
Q	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
R	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
S	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
T	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
U	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
V	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
W	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
X	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
Y	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29
Z	ADD BEVEL TO FWD END. ADD DETAIL B	CH	07.05.29

DESIGN: DS
CHECKED: [Signature]
MFG. APPR: [Signature]
APPROVED: [Signature]
DATE: 10.10.08

DART AEROSPACE USA, INC.
PORT HADLOCK, WA.
DRAWING NO. D2739
SHEET 1 OF 1
SCALE: NTS

RELEASED
2010-11-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries